

Date: Tuesday, 08/04/2008 12:52:59 PM
 User: Julie Lecocq

Process Sheet

| | | | | | | |
|-----------------------|---|--|--------------|------------------|---------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : STEP BRACKET | | |
| Job Number | : 38468 | | | Part Number | : D37291 | |
| Estimate Number | : 13161 | | | Drawing Number | : D3729 REV B | |
| P.O. Number | : | | | Project Number | : N/A | |
| This Issue | : 08/04/2008 | | S.O. No. : | Drawing Revision | : B | |
| Prsht Rev. | : NC | | | Material | : | |
| First Issue | : / / | | Type | : SMALL /MED FAB | | |
| Previous Run | : 37580 | | | Due Date | : 15/04/2008 | |
| Written By | : | | | Qty: | 8 Um: Each | |
| Checked & Approved By | : JD 08-04-08 | | | | | |
| Comment | : Est Rev:A 08-01-30 new issue DD verified by:EC Est Rev:B 08-02-26 ECN 1140p DD verified by: Est Rev:C 08-03-19 ecn 1158 DD verified by: | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|--|--|
| 1.0 | M6061T6B0500X05000 | 6061-T6 Bar .50" x 5.0" | |
| | | | |
| | | Comment: Qty.: 1.0062 f(s)/Unit Total : 8.0497 f(s) 6061T6 aluminium bar 5.00" X .50" thick (M6061T6B0500X05000) Batch: 106183 LR 8-4 | |
| 2.0 | WATER JET | FLOW WATER JET | |
| | | | |
| | | Comment: FLOW WATER JET 1-Cut as per Dwg D3729 Dwg Rev: B LR 8-4 Prog Rev: B | |
| | | 2- Deburr if necessary | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | |
| 4.0 | QC8 | SECOND CHECK | |
| | | | |
| | | Comment: SECOND CHECK | |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| | | | |
| | | Comment: SMALL & MEDIUM FAB RESOURCE 1 | |
| | | 1- open holes to finish size as per dwg D3729 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR:- | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------|------|----------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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| Customer: CU-DAR001 Dart Helicopters Services | | Drawing Name: STEP BRACKET |
| Job Number: 38468 | | Part Number: D37291 |
| Job Number: | |  |
| Seq. #: | Machine Or Operation: | Description : |
| 2- Deburr if necessary | | |
| 3- grind water jet marks all around bracket smooth ****do not grind inside where step extrusion goes**** | | |
| 6.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|  | |  <i>EB 08/04/15 (8)</i> |
| Comment: INSPECT WORK TO CURRENT STEP | | |
| 7.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|  | |  <i>SH 08/04/15 (X)</i> |
| Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 | | |
| 8.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|  | |  <i>BL 08-04-15 (X)</i> |
| Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION | | |
| 9.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|  | |  <i>X8</i> |
| Comment: PACKAGING RESOURCE #1 Identify with Dart part # using a fine point permanent marker and Stock Location: <u>GA</u> | | |
| 10.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|  | |  <i>ML 08/04/15 08/04/17 (J)</i> |
| Comment: FINAL INSPECTION/W/O RELEASE | | |
| Job Completion | |  <i>mf 08-04-16</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

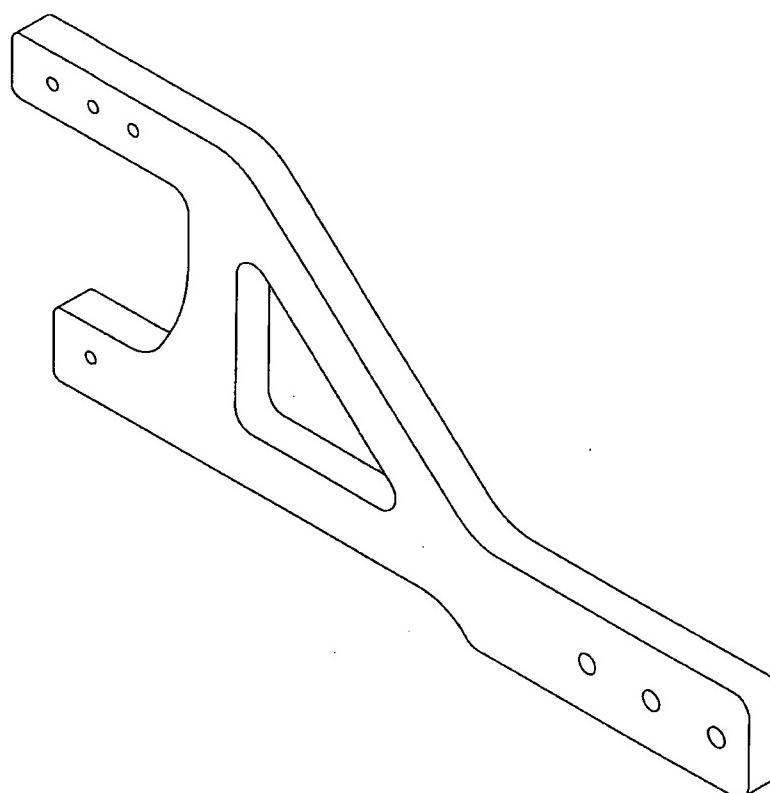
C

C

B

B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT:
WITHOUT NOTICE
WORK ORDER
NO. 39468



D3729-1 STEP BRACKET

28.03.17 JWS

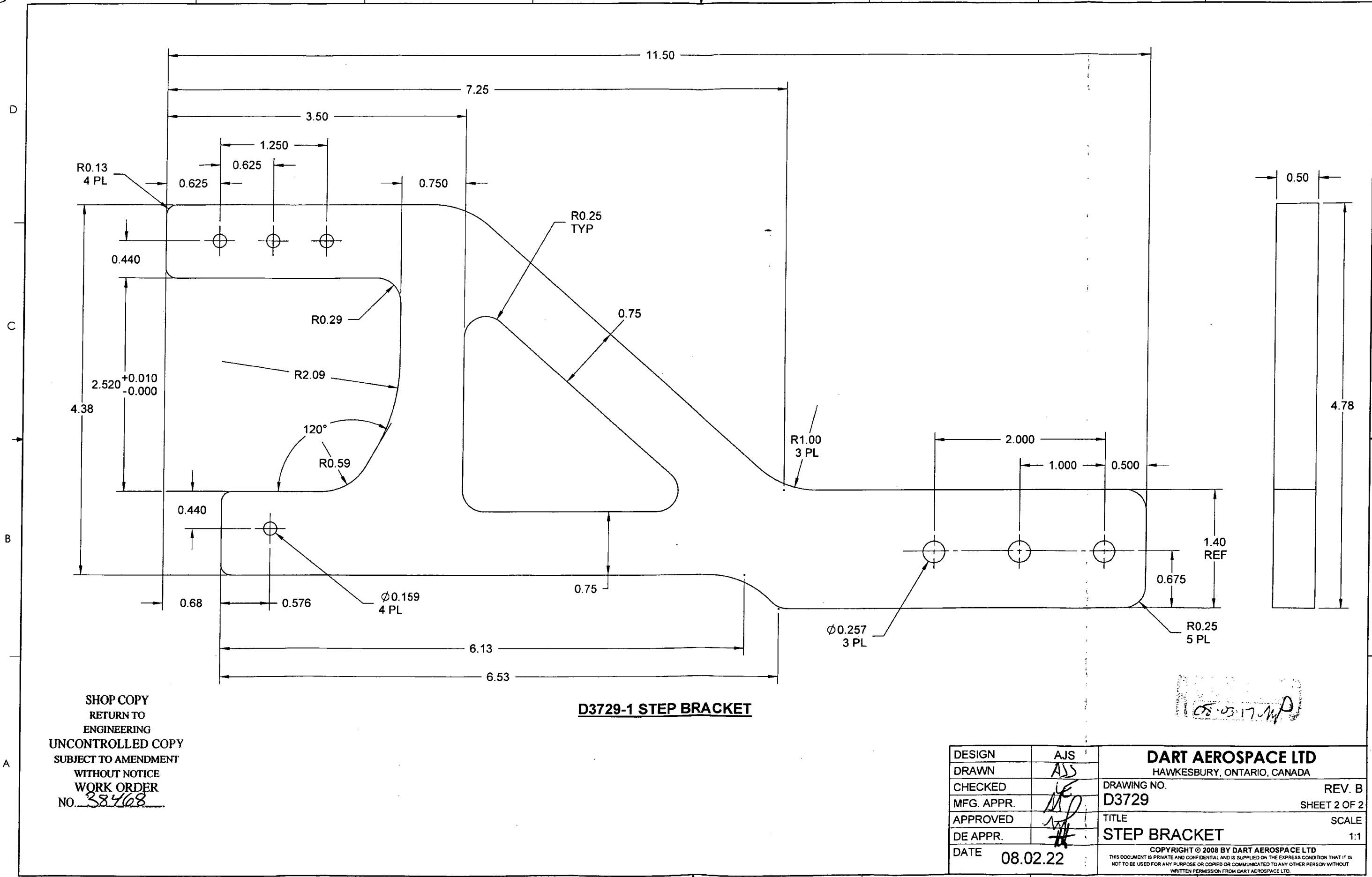
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.500 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.500)
OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs

| | | | |
|------------|--|--|--------------|
| B | SHEET 2 ZONE 4B Ø0.257 HOLE WAS Ø0.191, 8C 2.520 DIM WAS 2.51 & TOLERANCE HAS BEEN UPDATED. ZONE 7B & 7C Ø0.159 HOLES ADDED. | AJS | 08.02.22 |
| A | NEW ISSUE | AJS | 08.02.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JG | DRAWING NO. | REV. B |
| MFG. APPR. | M | D3729 | SHEET 1 OF 2 |
| APPROVED | JG | TITLE | SCALE |
| DE APPR. | H | STEP BRACKET | NTS |
| DATE | 08.02.22 | COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



| | | |
|--------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 38468 |
| Description: STEP BRACKET | Part Number: | D3729-1 |
| Inspection Dwg: D3729-1 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| | | | | | |
|--------------|-------|-------------|----------|---------------------|-----|
| Measured by: | (B) | Audited by: | (S) | Prototype Approval: | (A) |
| Date: | 8-4-9 | Date: | 08/04/09 | Date: | 14 |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

1